

# Work Order ID 53340

November 2, 2009 7:55:45 AM



Page 1

Item ID: D2893-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: 2.75 Support

Start Date: 02/11/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 09-11-02 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2893

Rev B

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA081 Tumble & Deburr

material = DSK078 = B47395 x 5

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

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Page 2

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M112148 Memo Mask Inside Bore for Priming <input type="checkbox"/> START TIME: 7:00 AM <input type="checkbox"/> OVEN TEMPERATURE: 7:30 AM <input type="checkbox"/> FINISH TIME: 4:00 PM	0.00 0.00				10	0		
140  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				10			
150  SprayPaint Spray Painting	SprayPaint Memo Prime inside surface as per Dwg D2893 and QSI 005 4.3	0.00 0.00				ml 09 11 19	10		

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Page 3

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Required Date: 10/11/2009 Req'd Qty: 20.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

85 09 11 24 (09)

170

Identify as per dwg & Stock Location: *8-tubes*

0.00



Packaging

Memo

0.00

Packaging

*m/l* 09 11 24 (10)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/25 *[Signature]*  
*m/f* 09-11-24

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	53340
<b>Description:</b> Ø2.750 Support		<b>Part Number:</b>	D2893-1
<b>Inspection Dwg:</b> D2893	<b>Rev:</b> B	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.995	2.995	2.994	2.994	2.993
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.138	.140	.138	.137	.137
AD	0.040	0.060		.050	.050	.049	.050	.051
AE	0.188	0.193		.191	.191	.191	.191	.191
AF	0.125	0.160		.137	.138	.140	.140	.139
AG	0.140	0.160		.152	.152	.150	.152	.150
AH	1.360	1.400		1.372	1.376	1.376	1.367	1.369
AI	0.040	0.060		.054	.055	.051	.053	.054
AJ	1.190	1.230		1.216	1.220	1.217	1.212	1.215
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.536	2.537	2.532	2.534	2.524
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.265	.264	.264	.264	.264
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by: mmf Date: 09/11/08

Audited by: SP Date: 09/11/10

Prototype Approval: \_\_\_\_\_ Date: \_\_\_\_\_

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 53340
<b>Description: Ø2.750 Support</b>		<b>Part Number:</b> D2893-1
<b>Inspection Dwg:</b> D2893	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
<b>HAAS Section</b>								
AA	2.985	3.005		2.994	2.994	2.994	2.994	2.995
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.147	.149	.146	.148	.146
AD	0.040	0.060		.050	.050	.049	.051	.051
AE	0.188	0.193		.191	.191	.191	.191	.191
AF	0.125	0.160		.138	.140	.140	.140	.140
AG	0.140	0.160		.150	.152	.150	.151	.150
AH	1.360	1.400		1.370	1.370	1.370	1.365	1.370
AI	0.040	0.060		.053	.054	.054	.053	.053
AJ	1.190	1.230		1.214	1.217	1.212	1.207	1.212
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.529	2.538	2.532	2.537	2.538
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.264	.264	.265	.265	.264
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
<b>Accept/Reject</b>								

<b>Measured by:</b> <i>mmf</i>	<b>Date:</b> 07/11/09
<b>Audited by:</b> <i>SA</i>	<b>Date:</b> 07/11/10
<b>Prototype Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	<i>[Signature]</i>

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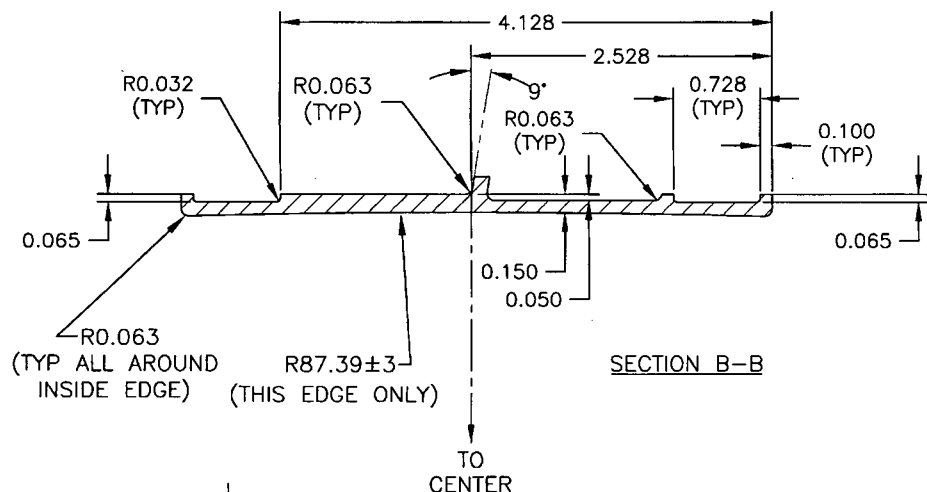
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 53343

11-2

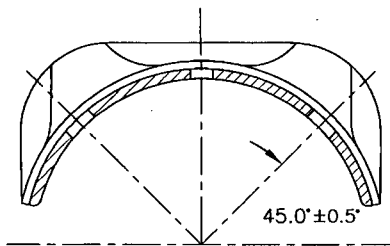
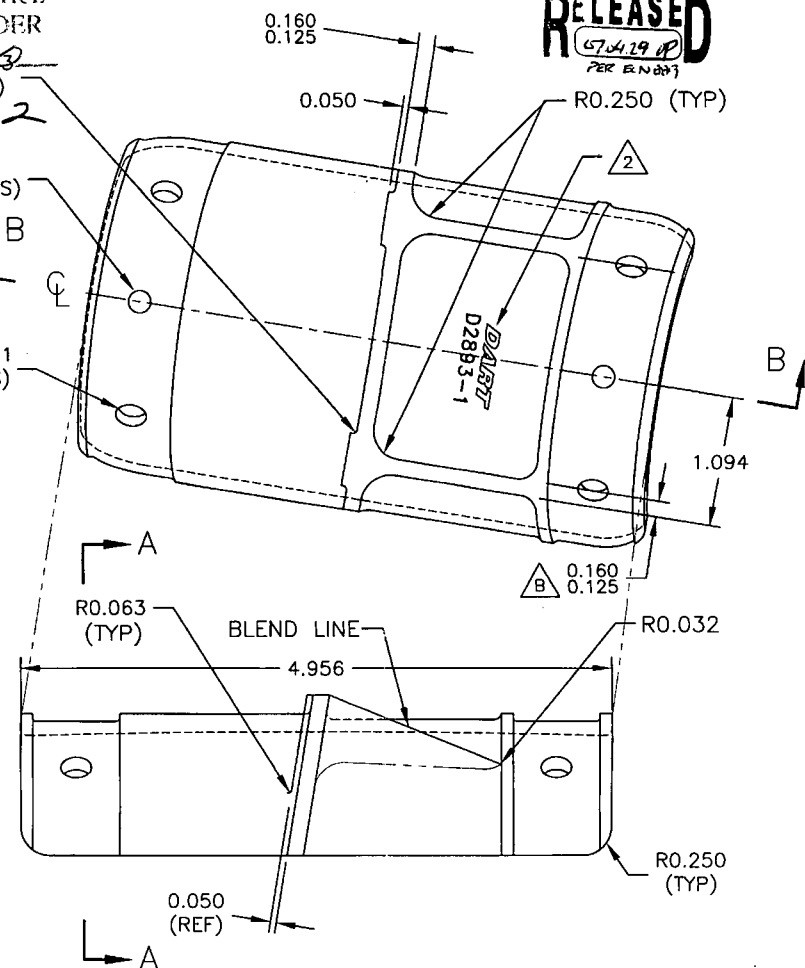
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PER B.N.007



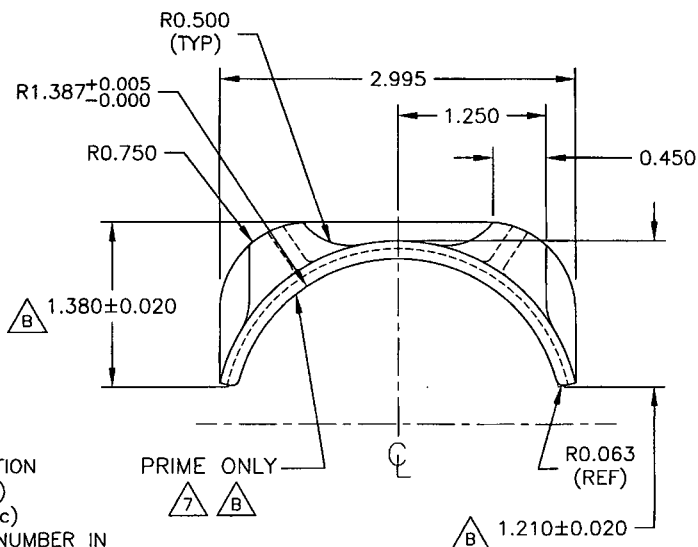
SECTION B-B

Ø0.188  
(TYP 2 PLACES)

Ø0.261  
(TYP 4 PLACES)



SECTION A-A  
TOOLING HOLE DETAIL



PRIME ONLY  
7 B

D2893-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL  
HEAT TREAT TO H900 CONDITION  
(900°F FOR 1 HR, AIR COOL)  
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN  
THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3  
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

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B	07.03.16	UPDATE DIMS AS MFG., PRIME INSIDE
A	01.01.10	NEW ISSUE
DESIGN	GP	DRAWN BY
CHECKED	PH	APPROVED
DATE	07.03.16	TITLE
		Ø2.750 SUPPORT

**DART** DART AEROSPACE LTD.  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.  
D2893  
REV. B  
SHEET 1 OF 1  
SCALE  
1:1